Work Order ID 94620

94620

December-19-12 1:13:52 PM

Item ID: D3500-1 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Saddle

Start Date: 12/24/12 **Start Qty:** 20.00 *20*
Required Date: 2/01/13 **Req'd Qty:** 20.00 *20*
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** 13-01-2 **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3500	C								
100	HAAS CNC VERTICAL MACHINING #1	0.00				20	0		DAS 08 9-89
100									
HAAS 1	**Memo**	0.00							
HAAS CNC vertical machine #1	Program Batch No. 94620 Double check by: BC 1-Machine Step No 1 per Folio FA641 and inspect per attached Dimension Sheets2-Machine Step No 2 per Folio FA641and inspect per attached Dimension Sheets3-Machine Step No 3 per Folio FA641 and inspect p								
110	QC2- Inspect parts off machine FAI/FAIB	0.00				20	0		DAS 08 9-89
110									
QC	**Memo**	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00				20	0		DAS 33 9-89
120									
QC	**Memo**	0.00							13.02.12
Quality Control									

ok 13/02/12 B.A 13/02/10

ok 13/02/12 B.A 13/02/10

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data										
Equip/Tooling										
Operator										
Material										
Setup										
Other										
Process										
Supplier										
Training										
Unapproved										

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

Work Order ID 94620

94620

December-19-12 1:13:52 PM

Item ID: D3500-1 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Saddle

Start Date: 12/24/12 **Start Qty:** 20.00 *20*
Required Date: 2/01/13 **Req'd Qty:** 20.00 *20*
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00				20		13-2-12	
130 HandFinish	**Memo**	0.00							
Hand Finishing									
140	White Gloss(Ref:4-3.5) per QSI005 4.3-Alum M123385	0.00				20		13-2-15	
140 Powdercoat	**Memo**	0.00							
Powder Coating	START TIME: 8:30 OVEN TEMPERATURE: 390 FINISH TIME: 9:00								
150	QC3- Inspect Part Finish	0.00				20			
150 QC	**Memo**	0.00							
Quality Control									

QAS 15 12-89 B.2 15

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped.
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____

Work Order ID 94620

94620

December-19-12 1:13:52 PM

Item ID: D3500-1 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Saddle

Start Date: 12/24/12 **Start Qty:** 20.00 *20*
Required Date: 2/01/13 **Req'd Qty:** 20.00 *20*
Reference:

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: ST 4 39A	0.00				20x			
160									13-2-19
Packaging	**Memo**	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									13/2/2013
QC	**Memo**	0.00							
Quality Control									

13-02-20

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

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- ☐ Turning Sequence
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- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____

Picklist Print

December-19-12 1:13:51 PM

Work Order ID: 94620

Parent Item: D3500-1

Parent Item Name: Saddle

Start Date: 12/24/12 **Required Date:** 2/01/13

Start Qty: 20.00 **Required Qty:** 20.00

Comments: IPP Rev:A New Issue 06-06-15 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6102-013 Saddle Billet		Manufactured	No			100	Each	108.0000	1	**20**	D.A	13/02/10	

Location	Loc Qty	Loc Code	
MAT043	8		
60713	8		
MAT045	50		
90316	50		
MAT046	50		
87453	38		
90085	12		

→ 95400

20.0

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
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- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

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- ☐ Hardware
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- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

DART AEROSPACE LTD								Work Order:	94620
Description: Saddle								Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C									Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		0.486	0.486	0.486	0.486		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		0.377	0.377	0.377	0.377		
F	0.490	0.510		0.500	0.500	0.500	0.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.588	1.589	1.588	1.588		
J	0.240	0.260		0.248	0.248	0.248	0.248		
K	0.490	0.510		0.502	0.507	0.502	0.507		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		0.316	0.316	0.316	0.316		
N	0.256	0.262		0.258	0.258	0.258	0.258		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.002	6.002	6.002	6.002		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.550	0.550	0.550	0.550		
V	0.793	0.803		0.798	0.798	0.798	0.798		
W	R.240	R.260		0.250	0.250	0.250	0.250		
X	0.040	0.060		0.050	0.050	0.050	0.050		
Y	0.100	0.120		0.105	0.105	0.105	0.105		
AA	R1.125	R1.145		1.135	1.135	1.136	1.134		
AB	R.490	R.510		0.500	0.500	0.500	0.500		
AC	0.615	0.635		0.635	0.635	0.635	0.635		
AD	0.240	0.260		0.253	0.253	0.253	0.253		
AE	1.810	1.830		1.824	1.824	1.824	1.824		
AF	0.240	0.260		0.251	0.251	0.251	0.251		
AG	0.140	0.160		0.152	0.152	0.152	0.152		
AH	0.140	0.160		0.158	0.158	0.158	0.158		
AI	0.140	0.160		0.158	0.158	0.158	0.158		
Accept/Reject									

Measured by:	D.a DAS
Date:	13/02/10 08

Audited by	DAS
Date:	13.02.17

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	

DART AEROSPACE LTD	Work Order:	94620
Description: Saddle	Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C		Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	#5	#6	#7	#8	By	Date
A	0.483	0.490		0.486	0.486	0.486	0.486		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		0.377	0.377	0.377	0.377		
F	0.490	0.510		0.500	0.500	0.500	0.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.589	1.590	1.589	1.589		
J	0.240	0.260							
K	0.490	0.510		0.502	0.502	0.502	0.502		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		0.316	0.316	0.316	0.316		
N	0.256	0.262		0.258	0.258	0.258	0.258		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.002	6.002	6.002	6.002		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.550	0.550	0.550	0.550		
V	0.793	0.803		0.798	0.798	0.798	0.798		
W	R.240	R.260		0.250	0.250	0.250	0.250		
X	0.040	0.060		0.050	0.050	0.050	0.050		
Y	0.100	0.120		0.105	0.105	0.105	0.105		
AA	R1.125	R1.145		1.136	1.135	1.135	1.136		
AB	R.490	R.510		0.500	0.500	0.500	0.500		
AC	0.615	0.635		0.635	0.635	0.635	0.635		
AD	0.240	0.260		0.253	0.253	0.253	0.253		
AE	1.810	1.830		1.824	1.824	1.823	1.823		
AF	0.240	0.260		0.251	0.250	0.251	0.251		
AG	0.140	0.160		0.157	0.152	0.152	0.152		
AH	0.140	0.160		0.158	0.158	0.158	0.158		
AI	0.140	0.160		0.158	0.158	0.158	0.158		
Accept/Reject									

Measured by:	D.A	DAS 08
Date:	13/02/10	

Audited by	
Date:	13.02.12

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	

DART AEROSPACE LTD	Work Order:	94620
Description: Saddle	Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C		Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	#9	#10	#11	#12	By	Date
A	0.483	0.490		0.486	0.486	0.486	0.486		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		0.377	0.377	0.377	0.377		
F	0.490	0.510		0.500	0.500	0.500	0.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.590	1.590	1.590	1.589		
J	0.240	0.260		0.248	0.248	0.248	0.248		
K	0.490	0.510		0.502	0.502	0.502	0.502		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		0.316	0.316	0.316	0.316		
N	0.256	0.262		0.258	0.258	0.258	0.258		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.002	6.002	6.002	6.002		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.550	0.550	0.550	0.550		
V	0.793	0.803		0.798	0.798	0.798	0.798		
W	R.240	R.260		0.250	0.250	0.250	0.250		
X	0.040	0.060		0.050	0.050	0.050	0.050		
Y	0.100	0.120		0.105	0.105	0.105	0.105		
AA	R1.125	R1.145		1.136	1.135	1.136	1.136		
AB	R.490	R.510		0.500	0.500	0.500	0.500		
AC	0.615	0.635		0.635	0.635	0.635	0.635		
AD	0.240	0.260		0.253	0.253	0.253	0.253		
AE	1.810	1.830		1.823	1.823	1.824	1.823		
AF	0.240	0.260		0.251	0.251	0.250	0.251		
AG	0.140	0.160		0.152	0.152	0.152	0.152		
AH	0.140	0.160		0.158	0.158	0.158	0.158		
AI	0.140	0.160		0.158	0.158	0.158	0.158		
Accept/Reject									

Measured by:	DAS
Date:	13/02/11 08:89

Audited by	DAS
Date:	13.02.12

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	

DART AEROSPACE LTD				Work Order:	94620				
Description: Saddle				Part Number:	D3500-1				
Inspection Dwg: D3500 Rev: C					Page 1 of 1				

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	#13	#14	#15	#16	By	Date
A	0.483	0.490		0.486	0.486	0.486	0.486		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		0.377	0.377	0.377	0.377		
F	0.490	0.510		0.500	0.500	0.500	0.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.590	1.590	1.589	1.590		
J	0.240	0.260		0.248	0.248	0.248	0.248		
K	0.490	0.510		0.502	0.502	0.502	0.502		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		0.316	0.316	0.316	0.316		
N	0.256	0.262		0.258	0.258	0.258	0.258		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.002	6.002	6.002	6.002		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.550	0.550	0.550	0.550		
V	0.793	0.803		0.798	0.798	0.798	0.798		
W	R.240	R.260		0.250	0.250	0.250	0.250		
X	0.040	0.060		0.050	0.050	0.050	0.050		
Y	0.100	0.120		0.105	0.105	0.105	0.105		
AA	R1.125	R1.145		1.136	1.136	1.136	1.136		
AB	R.490	R.510		0.500	0.500	0.500	0.500		
AC	0.615	0.635		0.635	0.635	0.635	0.635		
AD	0.240	0.260		0.253	0.253	0.253	0.253		
AE	1.810	1.830		1.824	1.823	1.824	1.824		
AF	0.240	0.260		0.251	0.250	0.250	0.251		
AG	0.140	0.160		0.152	0.152	0.152	0.152		
AH	0.140	0.160		0.158	0.158	0.158	0.158		
AI	0.140	0.160		0.158	0.158	0.158	0.158		
Accept/Reject									

Measured by:	D.A	DAO
Date:	13/02/11	08

Audited by	DAO
Date:	13 13.02.13

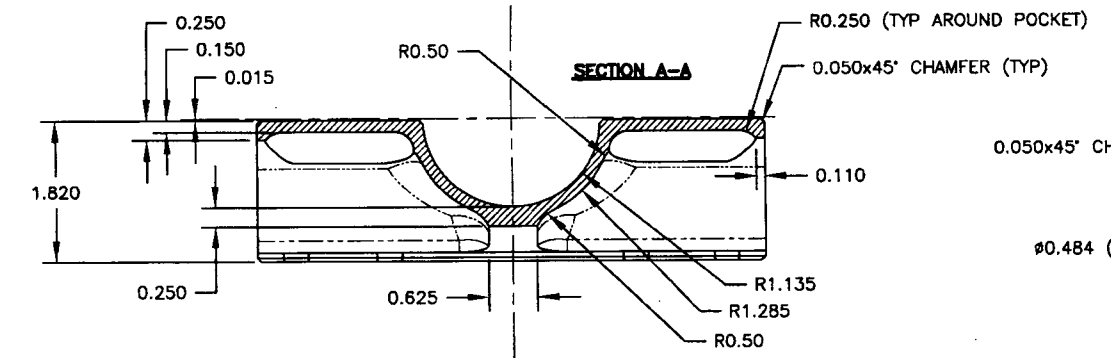
Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	

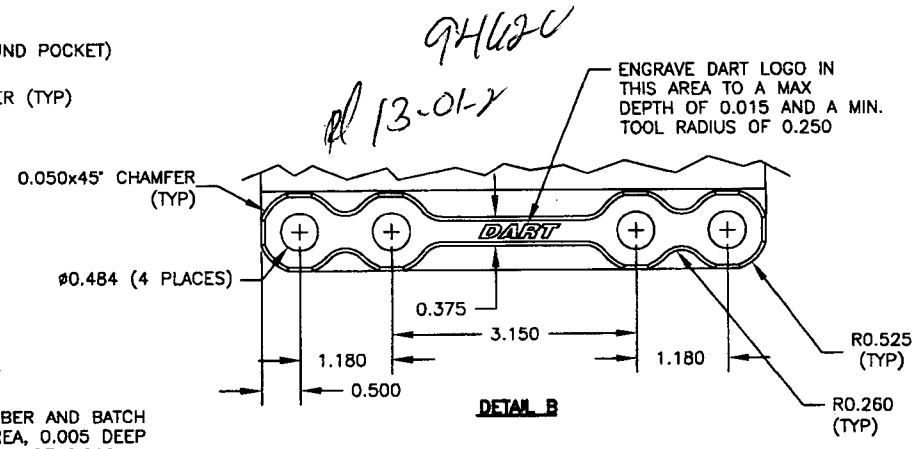
DART AEROSPACE LTD	Work Order:	94620
Description: Saddle	Part Number:	D3500-1
Inspection Dwg: D3500 **Rev:** C		Page 1 of 1

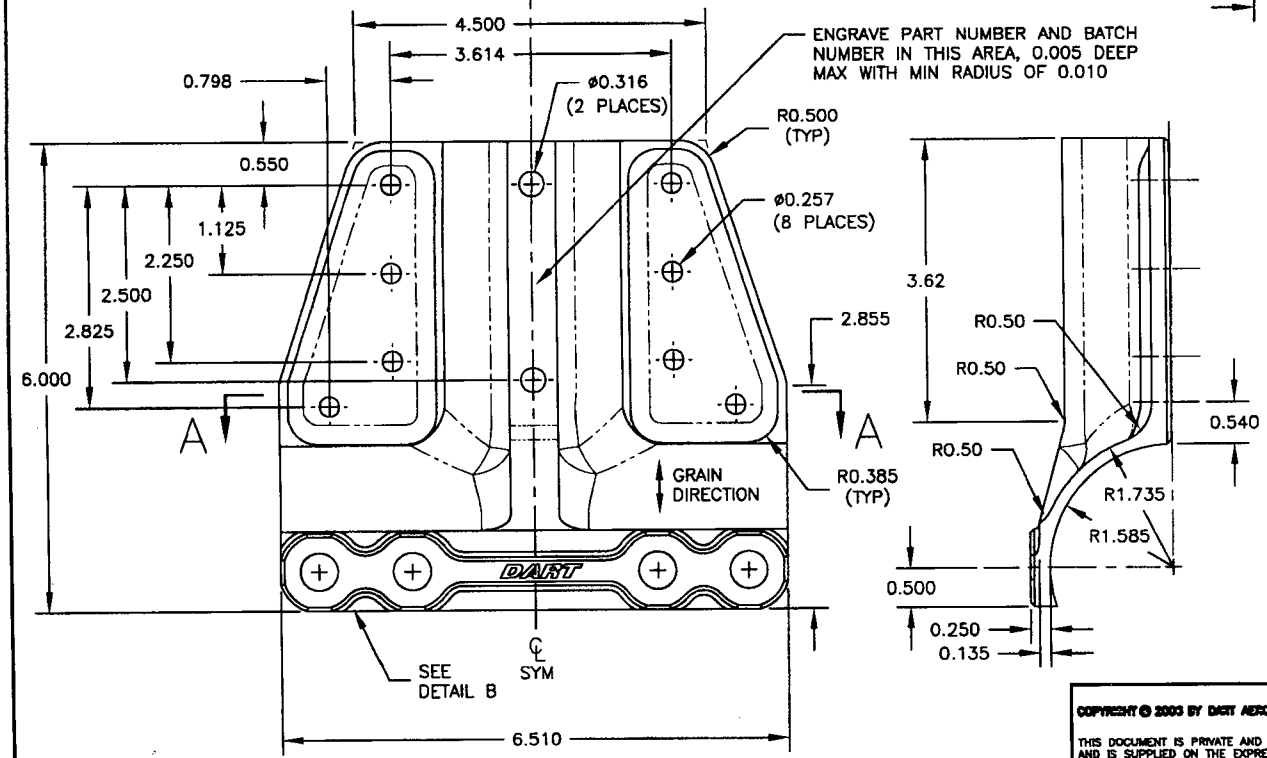
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	#17	#18	#19	#20	By	Date
A	0.483	0.490		0.486	.486	.486	.486		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		0.377	.377	.377	.377		
F	0.490	0.510		0.500	.500	.500	.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.590	1.5885	1.589	1.592		
J	0.240	0.260		.244	.246	.246	.245		
K	0.490	0.510		0.502	.500	.500	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		0.316	.316	.316	.316		
N	0.256	0.262		0.258	.258	.258	.258		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.002	6.001	6.001	6.001		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.550	.549	.549	.548		
V	0.793	0.803		0.798	.798	.798	.798		
W	R.240	R.260		0.250	.250	.250	.250		
X	0.040	0.060		0.050	.050	.050	.050		
Y	0.100	0.120		0.105	.105	.105	.105		
AA	R1.125	R1.145		1.135	1.138	1.134	1.136		
AB	R.490	R.510		0.500	.500	.500	.500		
AC	0.615	0.635		0.635	.635	.635	.635		
AD	0.240	0.260		.252	.250	.254	.252		
AE	1.810	1.830		1.821	1.821	1.820	1.823		
AF	0.240	0.260		.250	.250	.250	.252		
AG	0.140	0.160		.152	.152	.152	.154		
AH	0.140	0.160		.155	.157	.158	.158		
AI	0.140	0.160		.157	.158	.159	.159		
Accept/Reject									

Measured by:	D.A DAS		Audited by
Date:	13/02/11 08:00	13/02/12	Date: 13.02.12

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	







D3500–1 SADDLE

1) MATERIAL: 6061–T6/T651 (QQ–A–200/8 OR QQ–A–250/11) (MAKE FROM D6102–013 SADDLE BILLET, 6061)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1, POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
3) BREAK ALL SHARP EDGES 0.010 TO 0.020
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES

RELEASED
06.08.15

C	06.06.30	MAT'L NOW 6061–T6/T651
B	06.05.29	CHANGE DIMS; MAT'L NOW 7075–T7351
A	06.04.18	NEW ISSUE

DESIGN	DRAWN BY PH	DART AEROSPACE LTD. HAVERSBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3500	REV. C
DATE 06.06.30		TITLE SADDLE	SHEET 1 OF 1 SCALE 2:3